

Monday, November 07, 2016 3:04:09 PM

152739

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Chaffing Shield

Start Date: 11/1/2016 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 11/7/2016 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: Process Plan: DAS Date NOV 07 2016

Tooling:

Date:

Run Start *NR1*

QC: 21
9-89

Date:**Date:****SPC (Y/N):**

Date:

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
Description Work Order Deviation				Disposition																					
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

Work Order ID 152739***152739***

Page 2

Monday, November 07, 2016 3:04:09 PM

Item ID: D3189-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Chaffing Shield

Start Date: 11/1/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/7/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

105

QC8- Inspect parts - second check

0.00

105

QC

Memo

0.03

Quality Control

NOV 08 2016

110

Small Fab

0.00

110

Small Fab

Memo

0.08

Small Fab

1- Roll as per Dwg D3189

DAS
30
9-89

NOV 08 2016

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.03

Quality Control

DAS
38
9-89

NOV 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Monday, November 07, 2016 3:04:09 PM

Page 3

NS1

Stop ***NS2***

Run Start *NR1*

Stop *NR2*

LOCATION : LG051

15

DAS
38
9-99

16 DAS 26 9-89

16-11-8

NOV 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 152739

Monday, November 07, 2016 3:04:09 PM

152739

Page 4

Item ID: D3189-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Chaffing Shield

Start Date: 11/1/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/7/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.17

Quality Control

DAS
21
9-89

NOV 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER :					

Picklist Print

Monday, November 07, 2016 3:04:22 PM

Page 1

Work Order ID: 152739

152739

Parent Item: D3189-1

D3189-1

Parent Item Name: Chaffing Shield

Start Date: 11/1/2016

Required Date: 11/7/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP B05.08.22No longer made in-houseKJ/JLM
IPP Rev:C 06-03-24 Rolling Now made in House JLM
IPP Rev:D 07-04-16 As per Rev B JLM IPP Rev:E
11.05.11 now made on waterjet DD verf:JLM IPP REV:F 14.02.12
AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S24GA		Purchased	No				sf	99.4490		3.368421			

M304S24GA

304/316 .025 Sheet

**

22/11/07

Location

Loc Qty

Loc Code

MAT020

98.3

m135275

59.9

m135780

38.4

MAT20

1.149

m134677

1.149

4.2

DQA: _____ Date: _____

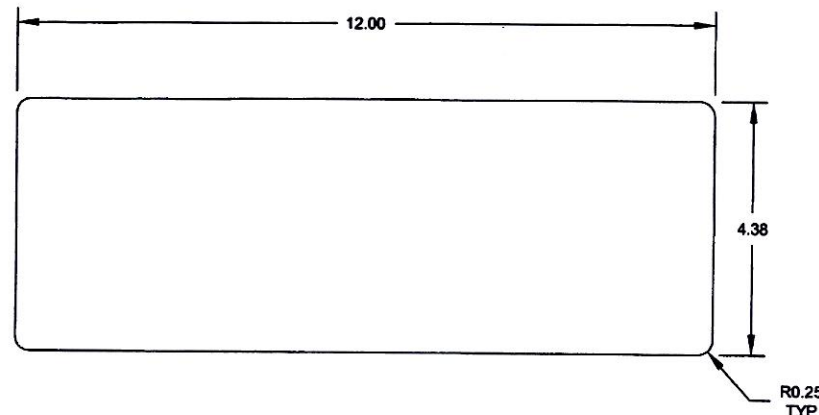
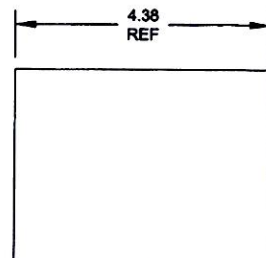
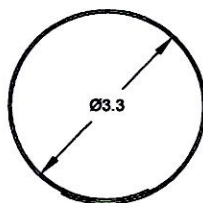


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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D3189-1 CHAFING SHIELD
(ROLL D3189-1F AS SHOWN)

D3189-1F FLAT PATTERN

RELEASED
2014-07-15

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NO. 152739 MJS
16-11-07

NOTES:

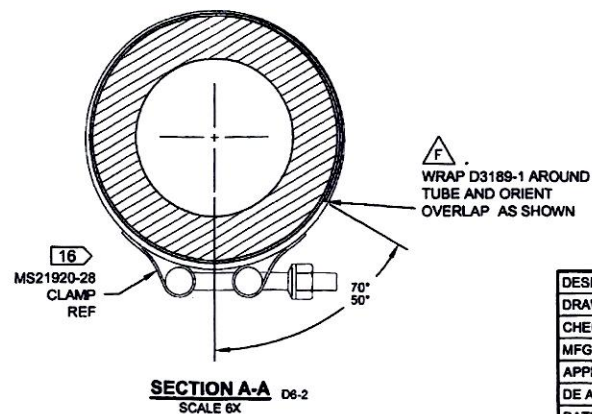
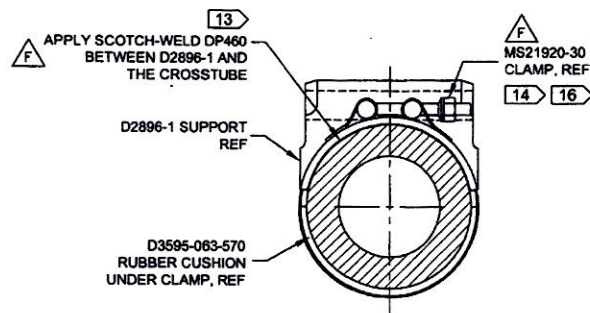
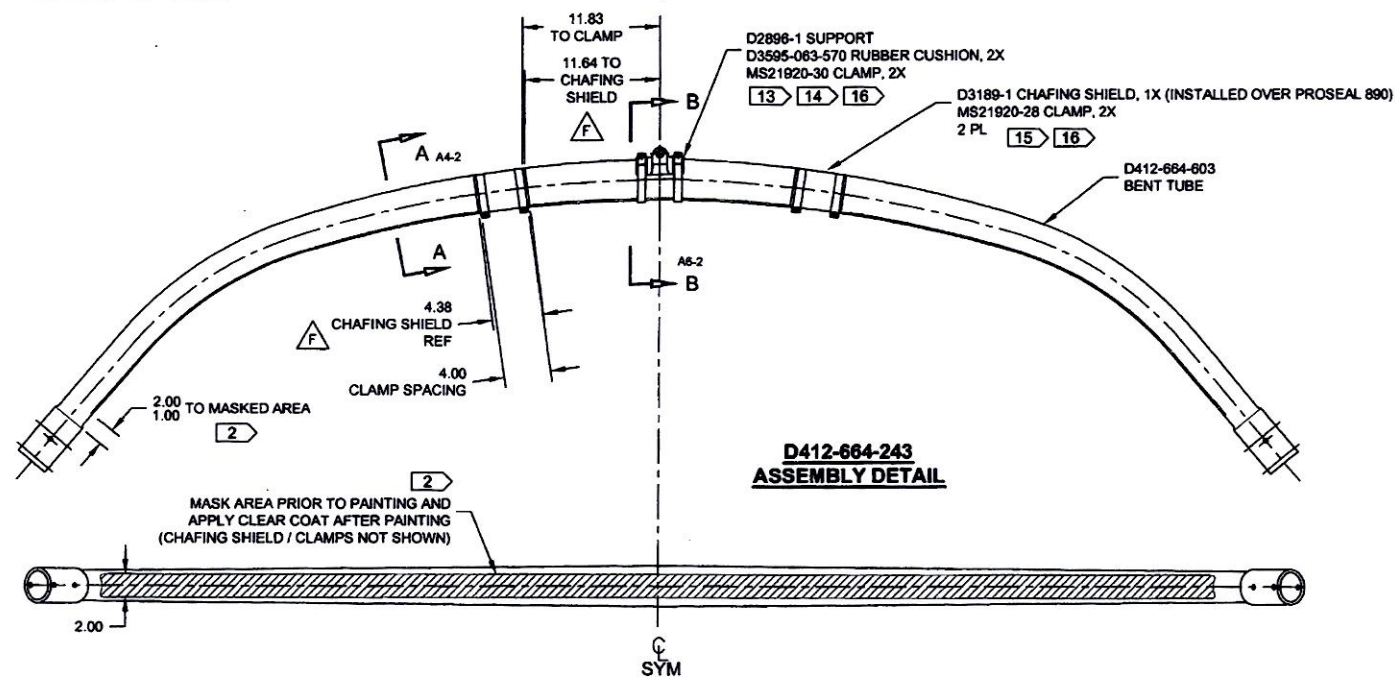
- 1) MATERIAL: AISI 304/316 SS, 24 GAUGE (0.025" THICK REF)
PER MIL-S-5059, AMS 5513, AMS 5524, ASTM A240, OR ASME SA240
REF. DART SPEC M304S24GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.30 lbs



D	24GA WAS 25GA (PAR 14-328)	CP	14.01.07
C	-1/-3 ENLARGED TO REDUCE CHANCE OF DMG TO CROSSTUBE, ALL FILLETS INCREASED TO R0.25	CP	12.08.14
B	ADD -3	CP	07.01.05
A	NEW ISSUE	CP	03.05.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	A.P.		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.01.07		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3189	REV. D
TITLE CHAFING SHIELD	SHEET 1 OF 2
SCALE	NTS

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DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D412-664-243	REV. F
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
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